

Work Order ID 66240

February 8, 2011 8:44:03 AM



Page 1

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 2/08/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/02/08 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

11-2-10

(10)

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-2-10

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Subtotal

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66240

February 8, 2011 8:44:03 AM



Page 2

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 2/08/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
	Memo	0.00							
	Packaging								
140	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Memo	0.00							
	Quality Control								

11/2/10 SF (102)

11/02/11 SF

ME
11-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 8:44:02 AM

Page 1

Work Order ID: 66240

Parent Item: D3536-23

Parent Item Name: Gasket



Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	177.5000	1.3365	14.85			
NEOPRENE SHEET 0.063													

B 11-210

Location

Loc Qty

Loc Code

MAT

177.5

115916

177.5

116832

116832

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	66240
Description: Gasket		Part Number:	D3536-23
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	X		T 1B01	
48.20	+/-0.030	48.20	X		T	
44.70	+/-0.030	44.70	X		T	
39.31	+/-0.030	39.31	X		T	
33.92	+/-0.030	33.92	X		T	
28.53	+/-0.030	28.53	X		T	
23.14	+/-0.030	23.14	X		T	
17.75	+/-0.030	17.75	X		T	
14.25	+/-0.030	14.25	X		T	
9.50	+/-0.030	9.50	X		T	
4.75	+/-0.030	4.75	X		T	
8.00	+/-0.030	8.00	Z		T	
16.00	+/-0.030	16.00	X		T	
24.00	+/-0.030	24.00	X		T	
32.00	+/-0.030	32.00	X		T	
39.00	+/-0.030	39.00	X		T	
48.00	+/-0.030	48.00	X		T	
0.30	+/-0.030	-302	X		V 1B02	
0.30	+/-0.030	305	X		V	
1.89	+/-0.030	-1804	X		V	
Ø0.19	+0.005/-0.001	.190	X		V	

Measured by:	RB
Date:	11-24-07

Audited by:	S
Date:	11/02/10

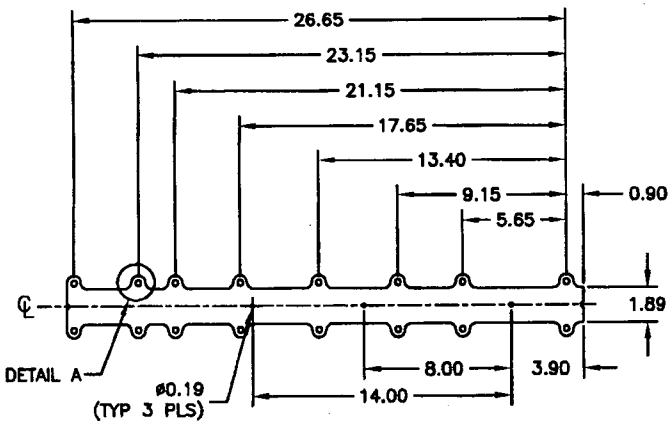
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	[Signature]

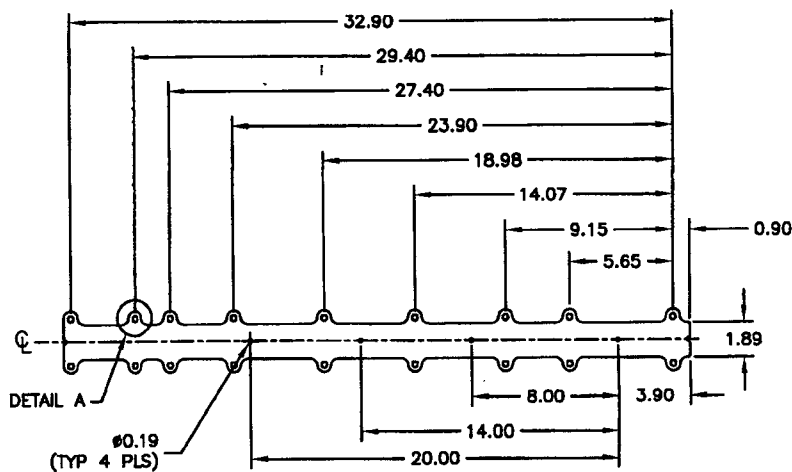
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10



D3536-11 GASKET



D3536-13 GASKET

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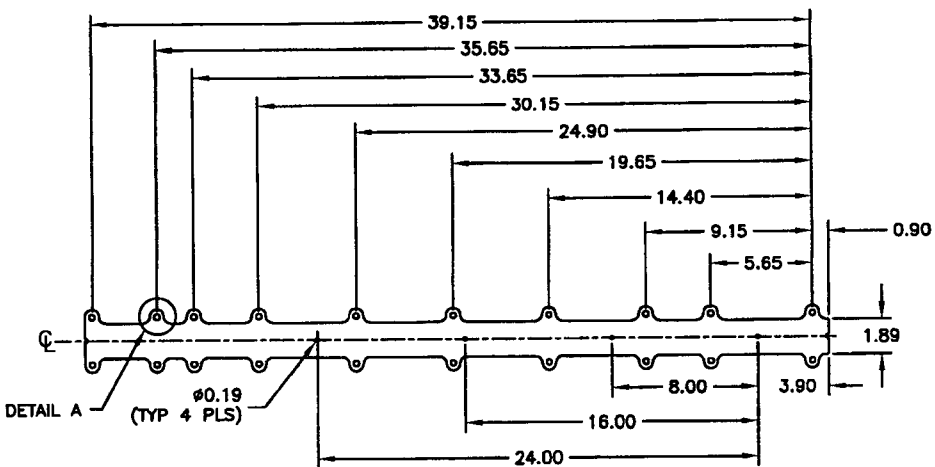
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

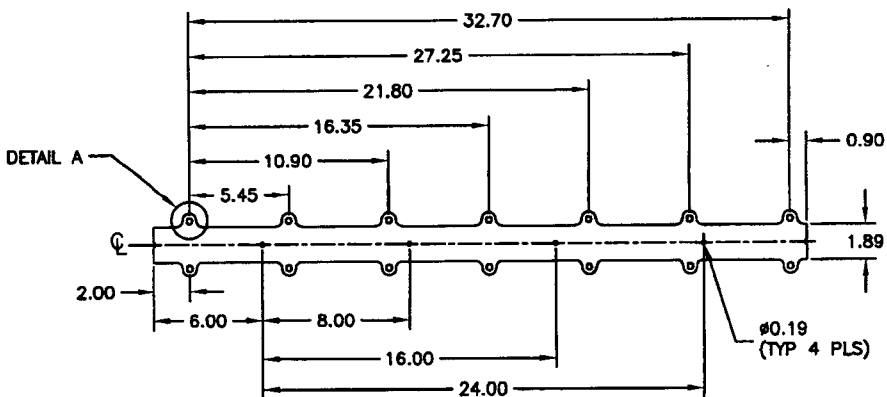
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		TITLE	GASKET	SHEET 2 OF 6
				SCALE 1:10

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D3536-15 GASKET



D3536-21 GASKET

NOTES

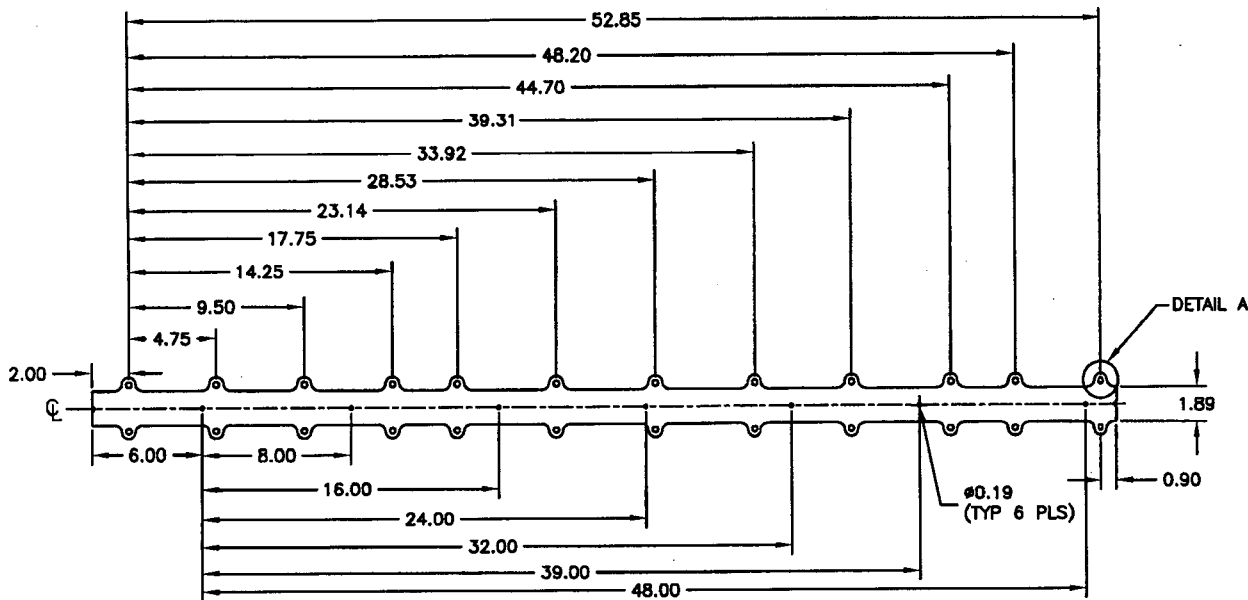
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		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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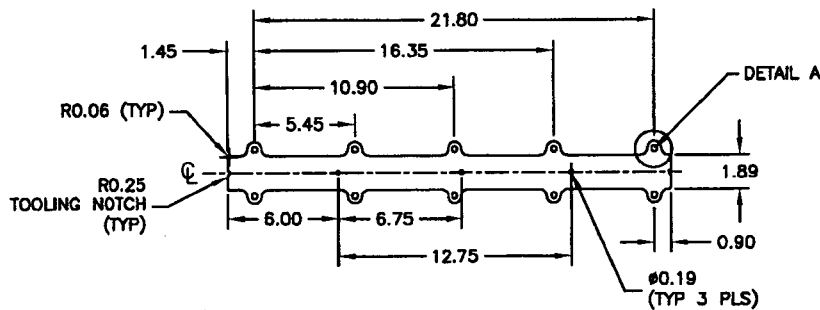


D3536-23 GASKET

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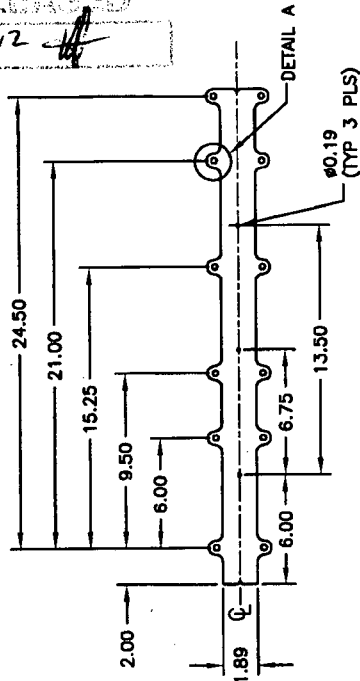
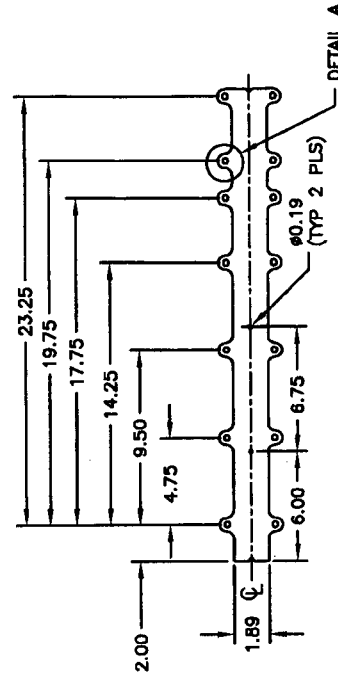
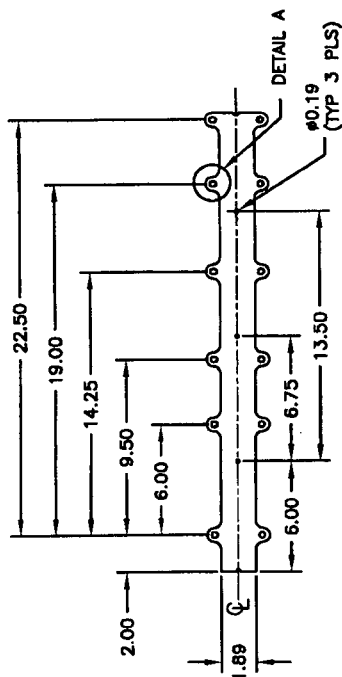
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**D3536-33 GASKET****D3536-35 GASKET****D3536-31 GASKET**

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- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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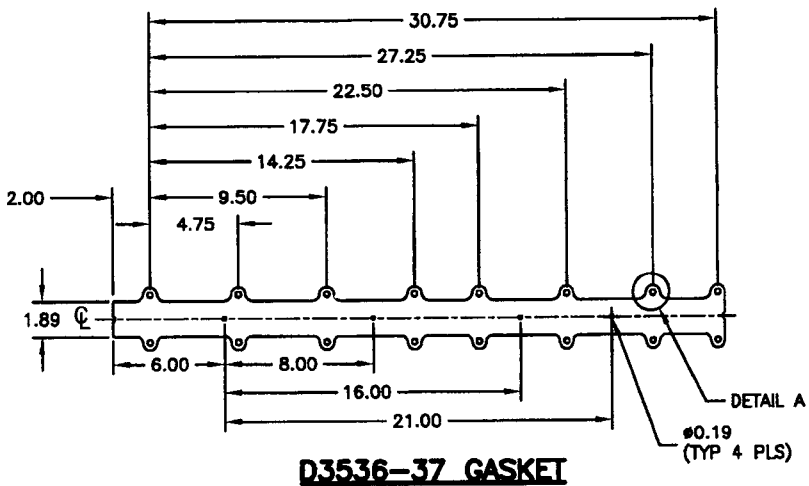
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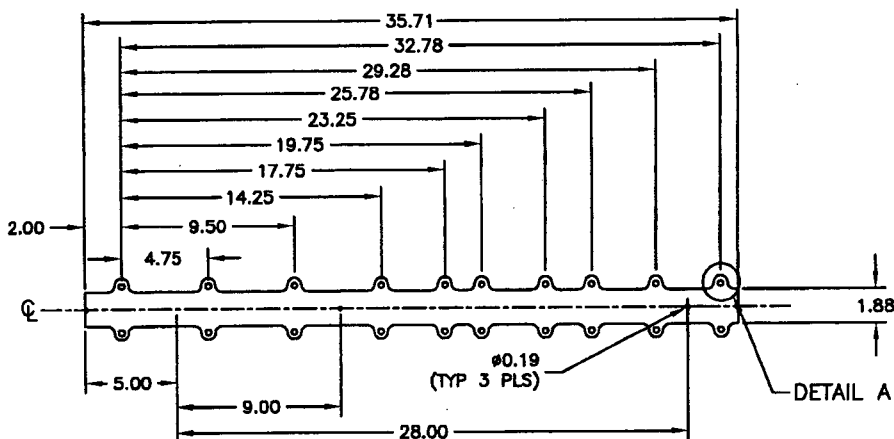


D3536-37 GASKET

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D3536-39 GASKET

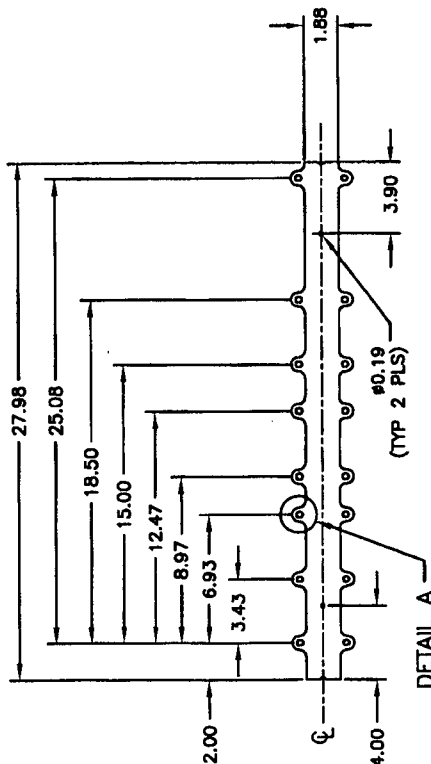
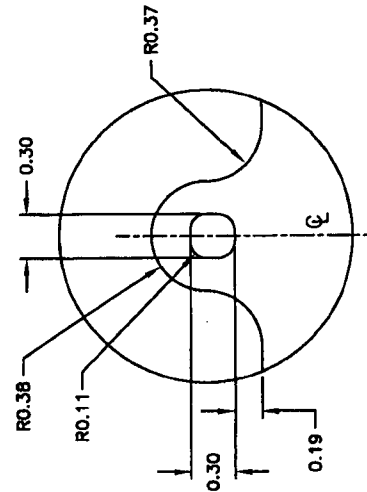
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DETAIL A



D3536-41 GASKET

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